



SECTION A - A

## NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL

2. BONDING ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10<sup>-10</sup> STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

ALCATEL ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MS-9, MS-90 OR MS-18  
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION

4. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

2	Ø.75 [22.24] & .063 [1.60] ADDED	M.J.M.		
1	Ø.03 [17.86]±.001 WAS			
	Ø.08 [17.98]±.001	M.J.M.	J.B.	2/4/97
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGULAR				
.X - .03 [.7620] - .25				
.XX - .01 [.254] - .125				
.XXX - .005 [.127] - .125				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER L2910204-02				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
DRAWN BY MUSCIA	DATE 10/17/95	CHIEF DESIGN ENGINEER D. SHU	DATE 6/23/96	TITLE ADVANCED PHOTON SOURCE
CHECKED BY D. SHU	DATE 6/23/96	GP LEADER T.M. KUZAY	DATE 6/26/96	L2-90 "PINK BEAM" SLIT/BPM COPPER TO METAL ADAPTER
DESIGNER SHU/MUSCIA	DATE 3/12/96	PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU	DATE 6/23/96	APPROVED/RELEASED		
MATERIAL SEE ABOVE			SCALE 1:1	SIZE C
			SHEET 1 of 1	DRAWING NUMBER L2-910204-02